

Work Order ID 145339

Thursday, May 05, 2016 1:38:55 PM

145339

Page 1

Item ID: D066-1001-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: R66 Bearpaws with Wearplates

Start Date: 5/17/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/27/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: ML5 Date: MAY 06 2016

Tooling:

Date:

Run Start

NR1

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D066-1001	REV B								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD066-1001-011								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									

DAS
21
9-89

16-06-15

4X DAS
27
9-89

AUG 24 2016

PC

DAS
28
9-89

JUL 07 2016

4X DAS
27
9-89

AUG 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER :									

Work Order ID 145339

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145339

Page 2

Item ID: D066-1001-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

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Cust Item ID:

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1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D066-1001-011								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

4X

DAS
27
9-89DAS
28
9-89

MAY 24 2016

DAS
21
9-89

AUG 24 2016

dem 16/08/24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
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LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Thursday, May 05, 2016 1:38:58 PM

Work Order ID: 145339

145339

Parent Item: D066-1001-011

D066-1001-011

Parent Item Name: R66 Bearpaws with Wearplates

Start Date: 5/17/2016

Required Date: 5/27/2016

Start Qty: 1.00

Required Qty: 1.00

D4930-1
D4930-1
Bearpaw

Manufactured No

Each 3.0000

****** 2 2 8
145724X 5 PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST454a

3

112358

3

D4952-041
D4952-041
Wearplate Assembly

Manufactured No

Each 6.0000

****** 4 3 16
X10XB147873 PC DAS 28 9-89
6XB145566

27
9-89

Location

Loc Qty

Loc Code

ST188

6

114155

6

D4953-1
D4953-1
Cushion

Manufactured No

Each 0.0000

****** 4 16
B144780 PC DAS 28 9-89

DAS
27
9-89

AN4-12A
AN4-12A
Bolt

Purchased No

Each 191.0000

****** 4 16
PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

120423

10

over003

125

m134606

125

ST344

56

m134180

56

JUL 07 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Picklist Print

Thursday, May 05, 2016 1:38:59 PM

Work Order ID: 145339

145339

Parent Item: D066-1001-011

D066-1001-011

Parent Item Name: R66 Bearpaws with Wearplates

Start Date: 5/17/2016

Required Date: 5/27/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-15A

Purchased

No

Each

320.0000

AN4-15A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

34

120449

34

over003

200

m134676

200

ST343

86

m134606

86

**

M135 127 PC
DAS
28
9-89

AN4-16A

Purchased

No

Each

252.0000

AN4-16A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

over003

100

M134702

100

ST343

147

M134509

32

M134606

115

**

134762 x 4 PC
135058 x 12 PC

DAS
28
9-89

JUL 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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145339

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Parent Item Name: R66 Bearpaws with Wearplates

Start Date: 5/17/2016

Required Date: 5/27/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each

1,420.000

NAS1149D0463.J

WASHER

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	328
M132035	21
M134508	307
ST260a	998
M134634	998
ST263	94
M134508	94

18 & 32
** 19 134754 PC DAS
9-89

X13 m/134754

MS21042L4

Purchased

No

Each

1,670.000

MS21042L 4

Locknut

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	279
m133769	279
OVER007	500
m134676	500
ST303	794
m134606	794
ST305	97
m130922	97

15 12 48
** 134861 PC DAS
9-89

JUL 07 2016

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Shop Packet Print

Page 4

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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY																																																												
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : ☐																																																															

Work Order ID 145339

145339

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Thursday, May 05, 2016 1:38:55 PM

Item ID: D066-1001-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: R66 Bearpaws with Wearplates

Start Date: 5/17/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/27/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: ML5 Date: MAY 06 2016

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D066-1001	REV B								
100-	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD066-1001-011		CHG 003						
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									

JUN 15 2016

ML5 JUN 15 2016

4

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D066-1001-011	8.3 lb	0.0 in	0.0 in-lb	123.89 in	1028 in-lb
<i>Bearpaw Installation (Small)</i>	3.74 kg	0.0 m	0.0 m-kg	3.14 m	11.7 m-kg
D066-1001-013	9.8 lb	0.0 in	0.0 in-lb	124.98 in	1225 in-lb
<i>Bearpaw Installation (Large)</i>	4.41 kg	0.0 m	0.0 m-kg	3.17 m	14.0 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D066-1001-011	BEARPAW INSTALLATION (SMALL)
	X	D066-1001-013	BEARPAW INSTALLATION (LARGE)
4	4	D3456-1	Washer
4	4	D3556-1	Clamp
8	8	D3601-1	Radius Block
2		D4930-1	Bearpaw
	2	D4930-3	Bearpaw
4	4	D4952-041	Wearplate
4	4	D4953-1	Cushion
4	4	AN4-12A	Bolt
4	4	AN4-15A	Bolt
4	4	AN4-16A	Bolt
8	8	NAS1149D0463J	Washer
12	12	MS21042L4	Nut (or MS21042-4)